

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET		
Job Number	: 31216				
Estimate Number	: 12538				
P.O. Number	: N/A	Part Number	: D35461		
This Issue	: 3/14/2007 S.O. No. : N/A	Drawing Number	: D3546 REV A		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: 3/14/2007 Type : SMALL /MED FAB	Drawing Revision	: A		
Previous Run	: 29766	Material	: N/A		
Written By	:	Due Date	: 3/23/2007	Qty:	40 Uin: Each
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 06-09-27 JLM				

Job Number:

1.0 M304S18GA 304/316 .050 Sheet

Comment: Qty.: 0.2205 sf(s)/Unit Total : 8.8200 sf(s)

304 SS SHEET 18GA

Batch: M100997

SAD 07/03/18

(40)

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: A

SAD 07/03/18

40

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/03/18

40

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

107/03/19

(40)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3546

SB 07/03/23

40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:29:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31216

Part Number: D35461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/26 (40)

7.0

POWDER COATING

POWDER COATING



N1103706



(40x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L.

07/03/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/27

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/27 (40)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/28

Job Completion



07/03/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

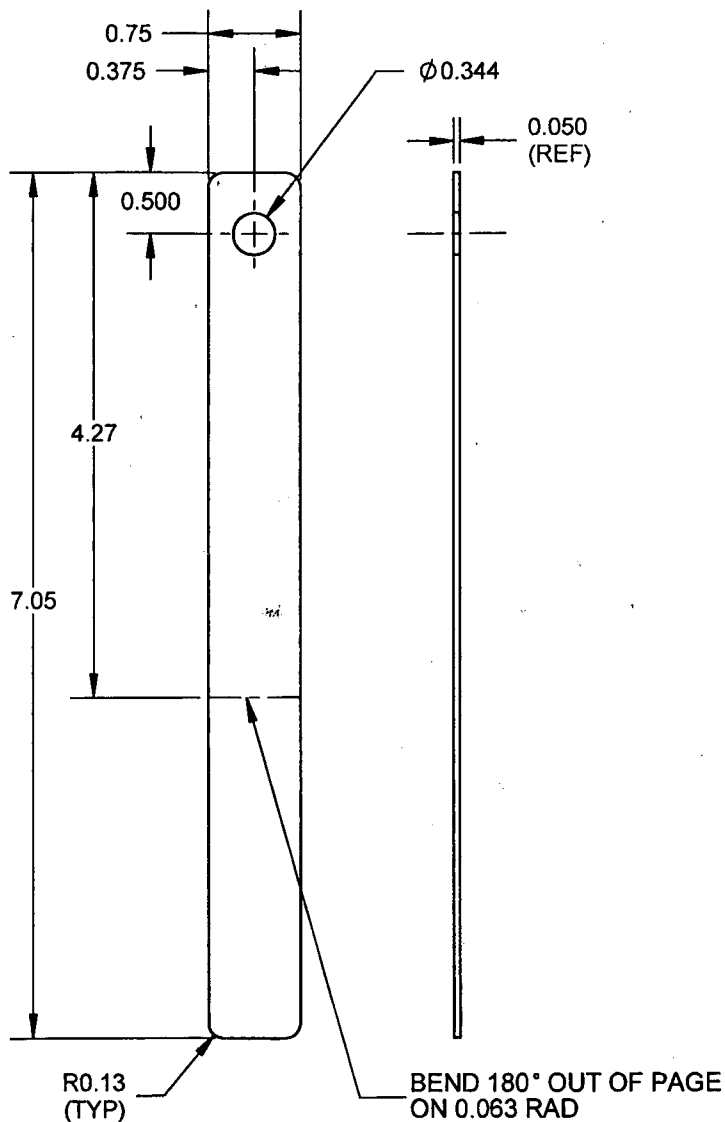
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

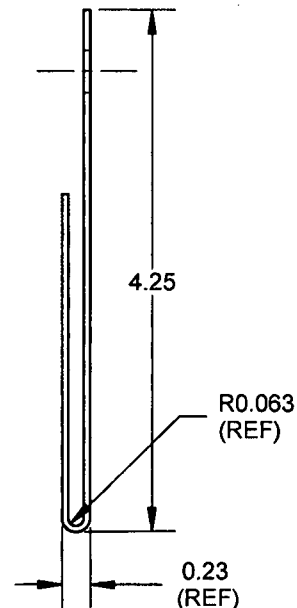
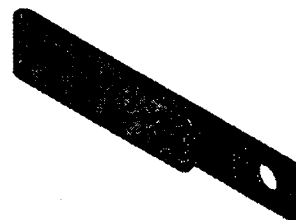
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE CLIP SCALE 1:1		
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3546-1F FLAT PATTERN



D3546-1 CLIP

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31216

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
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DART AEROSPACE LTD		Work Order: 31216
Description: BRACKET		Part Number: D3546-1
Inspection Dwg: D3546 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 7.05	+/- 0.030	7.05	✓		Vern	
B 0.500	+/- 0.010	0.497	✓		Vern	
C 0.750	+/- 0.010	0.754	✓		Vern	
D 0.375	+/- 0.010	0.374	✓		Vern	
E 0.050	+/- 0.010	0.049	✓		Vern	
F Ø 0.344	+0.006 -0.001	Ø0.346	✓		Vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: 	Prototype Approval: N/A
Date: 07/03/19	Date: 07/03/19	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

